

Work Order ID 64252

Tuesday, November 30, 2010 4:06:59 PM



Page 1

Item ID: D4030-041

Accept



Setup Start



Revision ID:

Item Name: Long Basket Assembly (350)

Stop



Start Date: 11/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 12/10/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

14

Date: 10-01-12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4030	C								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110	Assemble as per dwg	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

11/1/3

=) 10/10/10

1

S. L. 10/6

(H)

Work Order ID 64252

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Page 2

Item ID: D4030-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Long Basket Assembly (350)

Start Date: 11/30/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 12/10/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PPN
64201

0.00

Packaging

Cai 11/30/10

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/01/10
MF
11-01-07

Picklist Print

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Page 1

Work Order ID: 64252

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)



Start Date: 11/30/2010

Required Date: 12/10/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2530 Handle Weldment		Manufactured	No			100	Each	10.0000	1	1			
							B64443					11/01/06	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST506			10						
					62946		10						
D2535 Spring		Manufactured	No			100	Each	48.0000	2				
												11/1/38	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST504			48						
					58331		48						
D2537 Bushing		Manufactured	No			100	Each	30.0000	2				
												11/1/38	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST504			30						
					62393		30						
D3913-041 Long Basket Base Assembly, 350		Manufactured	No			100	Each	0.0000	1	1			
							B64253					11/01/05	
D3914-041 Long Basket Lid Assembly (350)		Manufactured	No			100	Each	0.0000	1	1			
							B64254					11/01/05	

Picklist Print

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Work Order ID: 64252

Parent Item: D4030-041

Parent Item Name: Long Bracket Assembly (350)

Start Date: 11/30/2010

Required Date: 12/10/2010

Start Qty: 1.00

Required Qty: 1.00

D3917-3

Manufactured No

100 Each

21.0000

6

6



Washer



B64589 11/1/35

Location

Loc Qty

Loc Code

ST095

20

63672

20

ST096

1

57144

1

D3953-3

Manufactured No

100 Each

3.0000

2

2



Gas Spring Stud, Lid



B64029 11/1/35

Location

Loc Qty

Loc Code

ST101

3

63673

3

D3953-7

Manufactured No

100 Each

4.0000

2

2



Spring Spacer



B64257 11/1/35

Location

Loc Qty

Loc Code

ST101

3

63674

3

ST103

1

59438

1

D3953-9

Manufactured No

100 Each

4.0000

2

2



Gas Spring Washer



B64450 11/1/35

Location

Loc Qty

Loc Code

ST101

2

63675

2

ST103

2

60008

2

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Work Order ID: 64252

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 11/30/2010

Required Date: 12/10/2010

Start Qty: 1.00

Required Qty: 1.00

D3953-17

Manufactured No

100 Each

18.0000

2

2



Gas Spring Spacer

Location

Loc Qty

Loc Code

ST101

18

57143

1

59197

2

64021

15

D3953-19

Manufactured No

100 Each

8.0000

1



Gas Spring Bracket

Location

Loc Qty

Loc Code

ST

8

59213

8

D3953-21

Manufactured No

100 Each

16.0000

1



Gas Spring Bracket

Location

Loc Qty

Loc Code

ENG

5

56407

5

ST102

11

57145

2

59214

9

D3969-3

Manufactured No

100 Each

5.0000

1



Spring (Basket Lid)

Location

Loc Qty

Loc Code

ST

1

58986

1

ST272

4

63657

4

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Page 4

Work Order ID: 64252

Parent Item: D4030-041


Parent Item Name: Long Bash Assembly (350)

Start Date: 11/30/2010


Required Date: 12/10/2010

Start Qty: 1.00


Required Qty: 1.00

AN3-14A Purchased No 100 Each 92.0000 4  4/11/38
Bolt


Location	Loc Qty	Loc Code
ST351	92	
114941	42	
115108	50	

AN3-16A Purchased No 100 Each 76.0000 2  2/10/11/38
Bolt

Location	Loc Qty	Loc Code
ST352	76	
114752	76	

AN5-17A Purchased No 100 Each 94.0000 4  4/11/14/38
Bolt

Location	Loc Qty	Loc Code
ST339	94	
114784	4	
115594	40	
116003	50	

AN4-12 Purchased No 100 Each 25.0000 3  3/11/11/38
Bolt

Location	Loc Qty	Loc Code
ST357	25	
114292	2	
114784	23	

Picklist Print

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Work Order ID: 64252

Parent Item: D4030-041


Parent Item Name: Long Basket Assembly (350)

Start Date: 1/30/2010


Required Date: 12/10/2010

Start Qty: 1.00


Required Qty: 1.00

AN310-4 Purchased No 100 Each 72.0000 3

 NUT 11/1/35

Location	Loc Qty	Loc Code
ST324	72	
115107	2	
115936	20	
116075	50	

AN310C4 Purchased No 100 Each 30.0000 2

 Nut 11/1/35

Location	Loc Qty	Loc Code
ST349	30	
114306	30	

MS21042L3 Purchased No 100 Each 1,515.000 6

 Nut 11/1/35

Location	Loc Qty	Loc Code
ST300	1515	
114784	519	
115835	996	

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Work Order ID: 64252

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 11/30/2010

Required Date: 12/3/2010

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

100

Each

1,325.0000

4

4



11/1/38

Nut

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

1299

115156

99

115594

500

116104

200

116105

500

MS24665-151

Purchased

No

100

Each

594.0000

3

3



11/1/38

Cotter Pin

Location

Loc Qty

Loc Code

ST309

594

17566

594

MS24665-300

Purchased

No

100

Each

44.0000

2

2



11/1/38

Cotter Pin

Location

Loc Qty

Loc Code

ST309

44

105279

2

110123

42

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Work Order ID: 64252

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 11/30/2010

Required Date: 12/10/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0432P

Purchased

No

100

Each

250.0000

6

6



Washer



11/16/39 11/1/35

Location

Loc Qty

Loc Code

ST275

250

112940

92

114405

1

114576

10

114718

2

116169

145

NAS1149F0563P

Purchased

No

100

Each

180.0000

4

4



Washer



11/1/35

Location

Loc Qty

Loc Code

ST275

2

108471

2

ST298

178

114576

178

NAS1149F0332P

Purchased

No

100

Each

451.0000

8

8



WASHER



11/1/35

Location

Loc Qty

Loc Code

ST275

451

18057

451

NAS1149C0432R

Purchased

No

100

Each

330.0000

2

2



Washer



11/1/35

Location

Loc Qty

Loc Code

ST297

330

114292

50

114742

280

Tuesday, November 30, 2010 4:07:03 PM

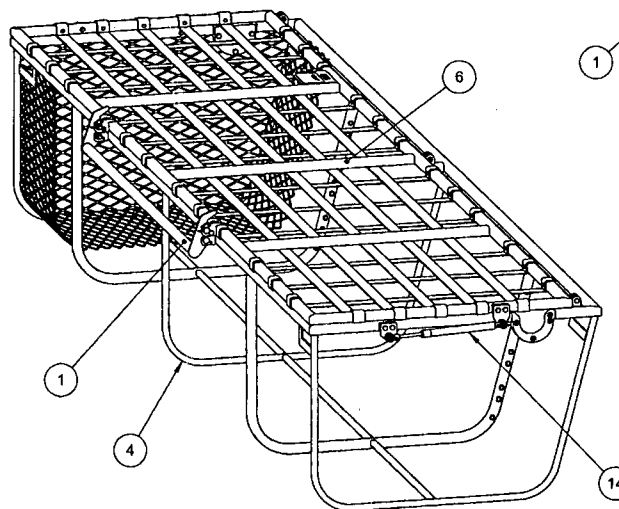
Shop Packet Print

Page 7

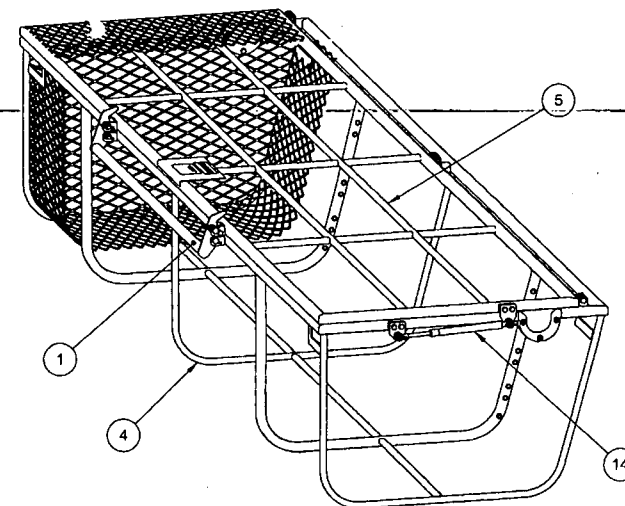
ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET LID ASSY (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 64252
B/10-01-12



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.12
ECN 10-596

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

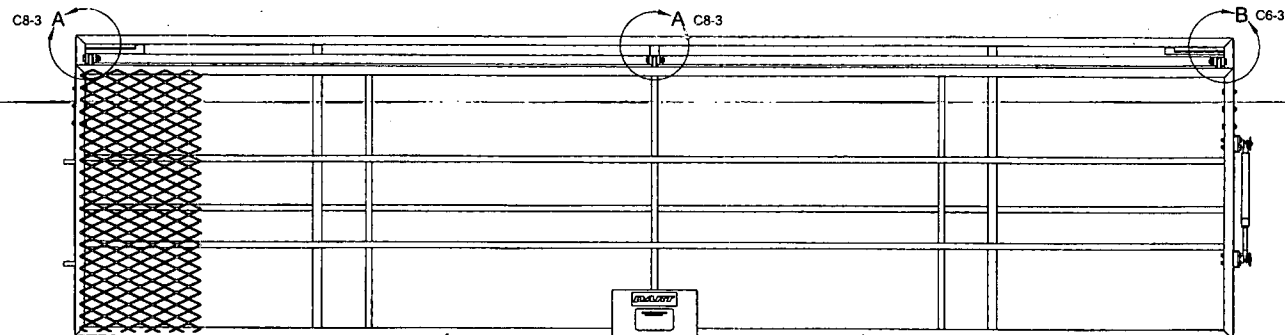
C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B3-1); QTY FOR ITEM #3 WAS 4 (D3-1) ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3)	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DESIGN		
DRAWN	DRAWN		
CHECKED	CHECKED		
MFG. APPR.	MFG. APPR.		
APPROVED	APPROVED		
DE APPR.	DE APPR.		
DATE	10.07.23		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

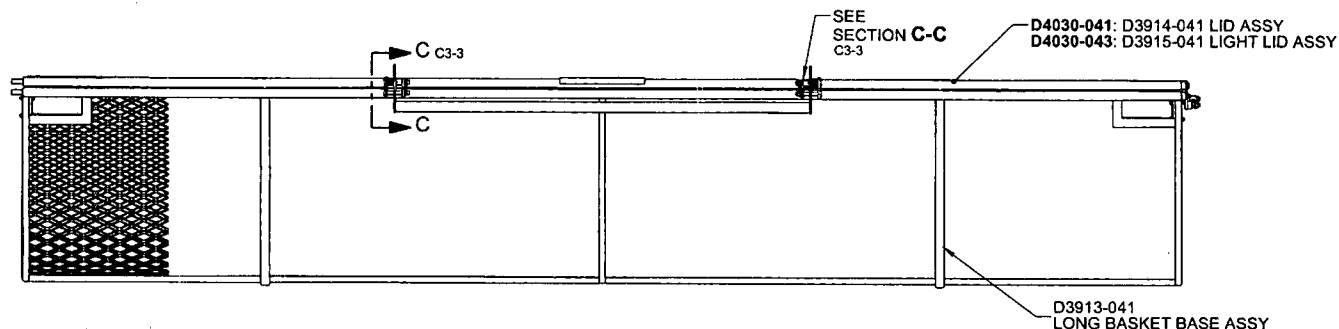
DRAWING NO. **D4030** REV. C
TITLE **LONG BASKET ASSY (350)** SCALE
SHEET 1 OF 3

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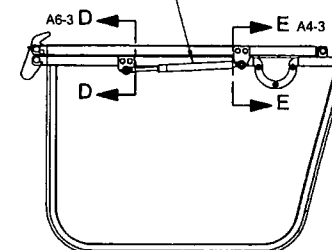
8 7 6 5 4 3 2 1



D2530
HANDLE WELDMENT



D3969-3 SPRING



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

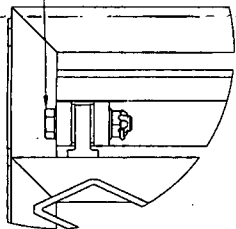
D4030-043 SHORT BASKET ASSY. LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.17

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	h	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	SFS	D4030	SHEET 2 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	LONG BASKET ASSY (350)	NTS
DATE	10.07.23	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

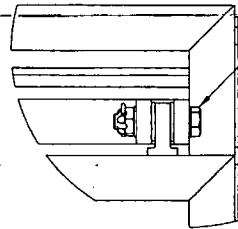
8 7 6 5 4 3 2 1

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



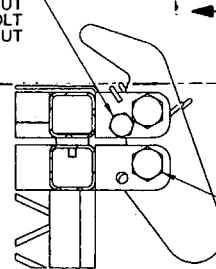
DETAIL A D8-2
D5-2

D4030-041: AN3-16A BOLT
MS21042L3 NUT
J4030-043: AN3-20A BOLT
MS21042L3 NUT



DETAIL B D3-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN

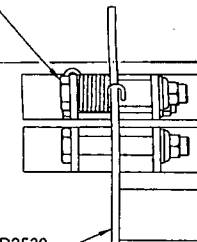


SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

AN5-17A BOLT
NAS1149F0563P WASHER
MS21042L5 NUT



VIEW F-F C3-3

D2530
HANDLE WELDMENT
REF

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

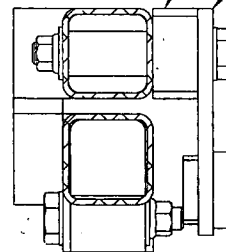
D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL



SECTION E-E B1-2

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

W/O 64252

RELEASED
10.08.124

DESIGN	AS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	JFS	D4030	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET-ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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